

Date: Tuesday, 01/04/2008 3:45:00 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE BLOCK
Job Number :	38274		
Estimate Number :	10324		
P.O. Number :		Part Number :	D1049
This Issue :	01/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D1049 REV A
First Issue :	01/04/2008	Project Number :	N/A
Previous Run :	36465	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	24/04/2008
Written By :		Qty:	50
		Um:	Each
Checked & Approved By :	JO 08.04.01		
Comment :	Est RevC 02.04.10 Re-format NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
 Material: 6061-T6 bar .750 wide x .250 thick.
 Batch M1107904

M.A 08/05/21

2.0	SHEAR	SHEAR
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Comment: ~~SHEAR~~ BAND SAW
 Cut Blanks: 2.000" long

M.A 08/05/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

J.L 08/06/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/06/02

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08.06.01 (SC)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:45:01 PM
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Process Sheet

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Drawing Name: SADDLE BLOCK

Job Number: 38274

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: RB/F, B

Handwritten: 150, 30 min, 09/06/2008

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Handwritten: M105642

Handwritten: m

Handwritten: S.298, 10.51, #1 319.6 F, #2 B38827 F, #3 B38827 F, #4 D1044 F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: F2, 08/06/09, 50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STQ

Handwritten: AS, 08/06/09, 50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08/06/10, 50

Job Completion



Handwritten: U, 08-06-10

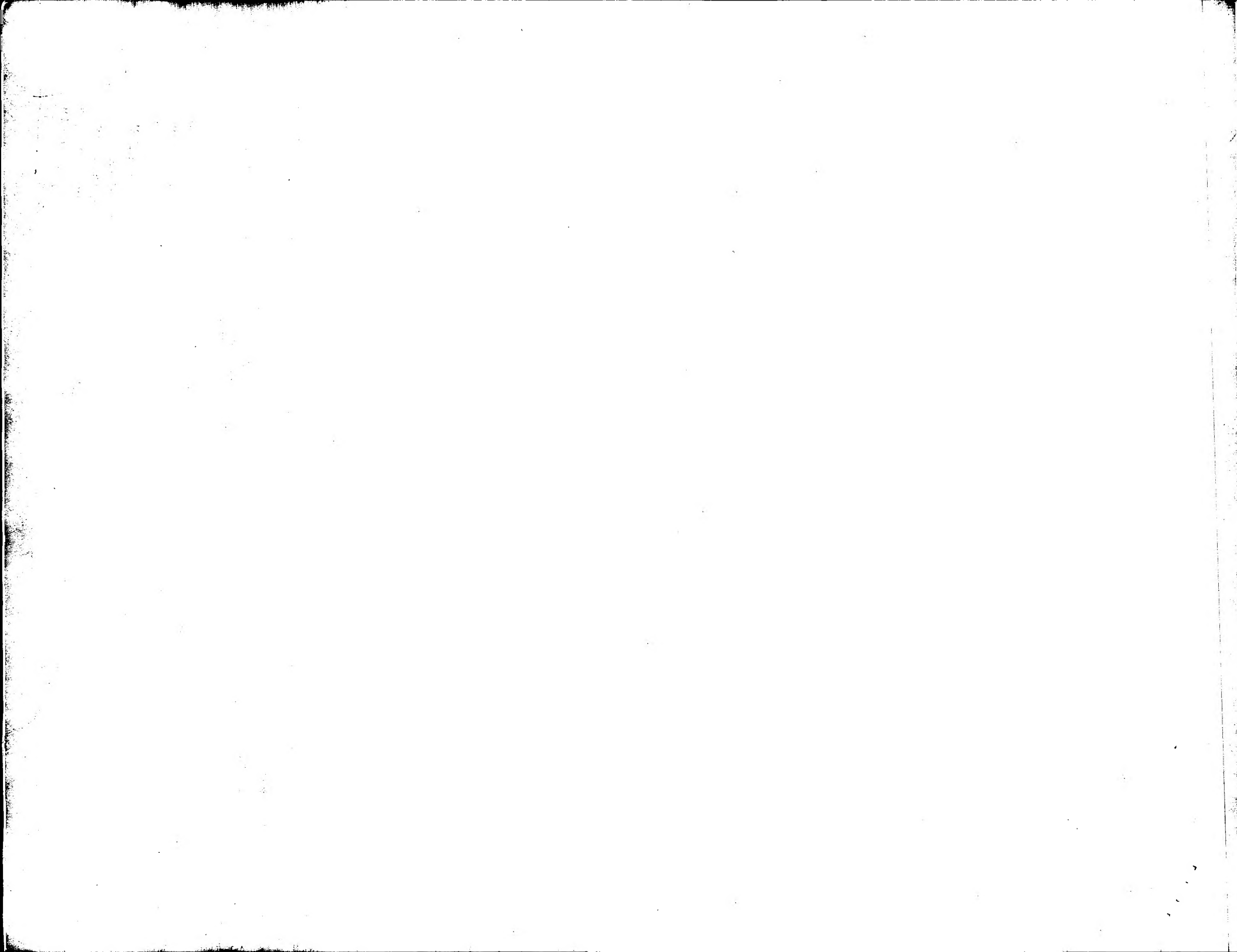
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

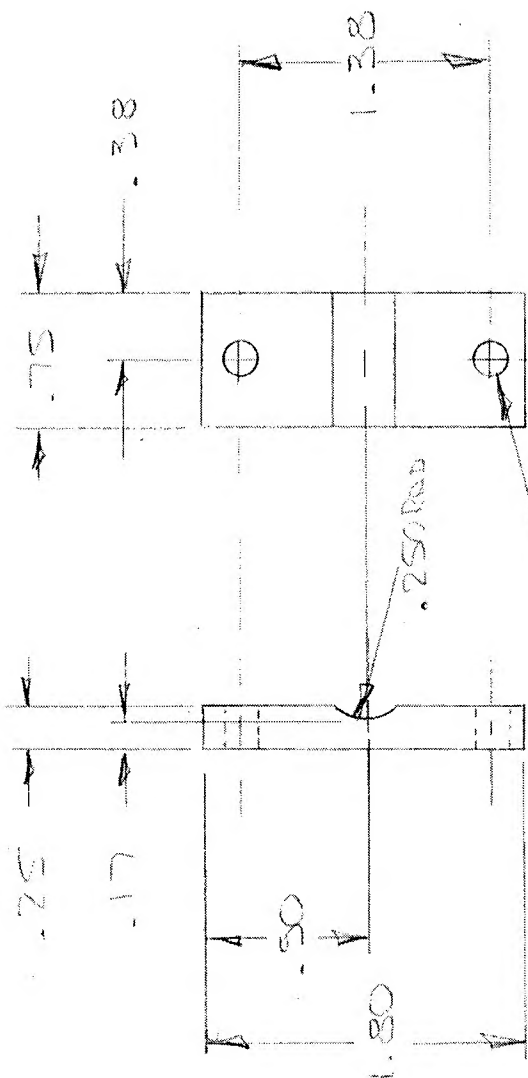
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
R 9710402 B.W.



.203 DIA.
TYP

MATERIAL: 5057-H32

FINISH: POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38724



REVISION		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC / VENDOR	
DRAWN		CONTRACT NO.						DART		DART AERO ACCESSORIES INC. CANADA	
APPROVED		DRAWN		DATE				VANDER			
DESCRIPTION		DESIGN		DATE				TITLE		SADDLE	
OF		STRESS						CODE		D1049	
CHANGE		CHECKED						DWG NO		D1049	
		CUT						SCALE		SHEET OF	

THE DRAWING IS PRINTED AND CONFORMS TO THE SPECIFICATIONS AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

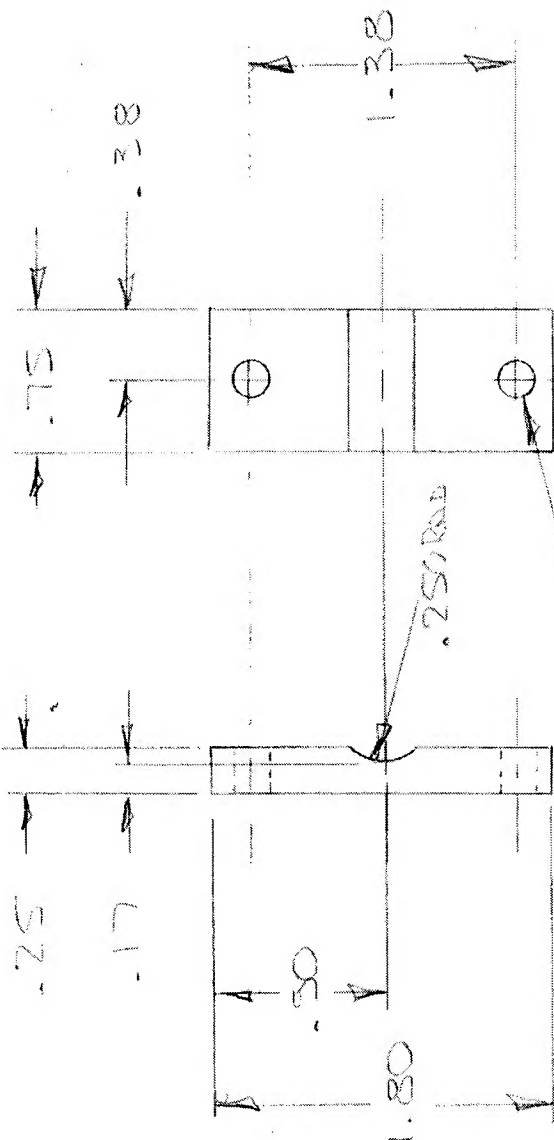
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL	LIMITS
1. DIMENSIONS ARE IN INCHES	1. TOLERANCES — SEE 4.200
2. SURFACE FINISHES ARE:	2. ANGLES
3. SURFACE FINISHES ARE:	3. PARALLELISM
4. PERIODICITY	4. PERIODICITY
5. HOLE PER AND 10007	5. HOLE PER AND 10007

REPORT ALL DISCREPANCIES — DO NOT SCALE

RELEASED

9710102 B3



.203 DIA.
TYP

MATERIAL: 5052-H32

FINISH: POWDER COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38724

REVISION	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC. VENDOR
DRAWN	CONTRACT NO.			DART	DART AERO ACCESSORIES INC.
APPROVED	DRAWN	DATE		VANCOUVER	CANADA
DESCRIPTION OF CHANGE	DESIGN	DATE		TITLE	
	STRESS			SADDLE	
	CHECKED			CODE	
	CLERK			DWG NO	
				SCALE	SHT OF
					D1049

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REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL	1. DIMENSIONS ARE IN INCHES	1. TOLERANCES —
	2. SURFACE FINISHNESS —	XXX ± .010
	3. REMOVE SHARP EDGES .015 MAX	XXX ± .010
	4. SURFACE FINISHNESS —	XXX ± .010
	5. SURFACE FINISHNESS —	XXX ± .010
	6. HOLE PER AND TOLERANCE	XXX ± .010

REPORT ALL DISCREPANCIES — DO NOT SCALE

